



Dart Aerospace Ltd.
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RBW6405G08632-3G

Job Sheet 194338



Part No: RBW6405G08632-3G

Job Qty: 1 pcs

Part Name: AW139 Tail Rotor Bushing Removal/Install



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/30/19

Job Tracking No:

Due Date: 6/24/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6405G08632-3G Rev B IPP Rev.A 17.09.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - Issue SN	1 pcs	6/24/19		0.00	0.28	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
110	Small Fab - 2 - B4B	1 pcs	6/24/19		0.00	0.33	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	6/24/19		0.00	0.00	QC 4 - 28		DAS 40 9-89
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
							QC 4 - 68		
130	Packaging 3-1 - Stock - B4B	1 pcs	6/24/19		0.00	0.00	Packaging 3 - 1 - B4B		JUL 10 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		



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Container No: S197006



Part: RBW6405G08632-3G

Job No: 194338

Serial No/Batch: S197006

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 07/10/19

Plex 7/9/19 3:40 PM Dart.Sauve.Jean-Francois

GA 060F

140 - (QC21- Final Inspection - Work Order Release)

96

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Issue SN	97524A032	4	173	0
110-Small Fab - 2 - B4B	APP-1200-E	1	14	0
	RB41011	1	281	0
	RBW6405G08632-3G-07	1	2	0
	RBW6405G08632-3G-09	1	2	0
	RBW6405G08632-3G-13	1	1	0
	RBW6405G08732-3G	1	1	0
	RBW6405G08832-3G	1	1	0

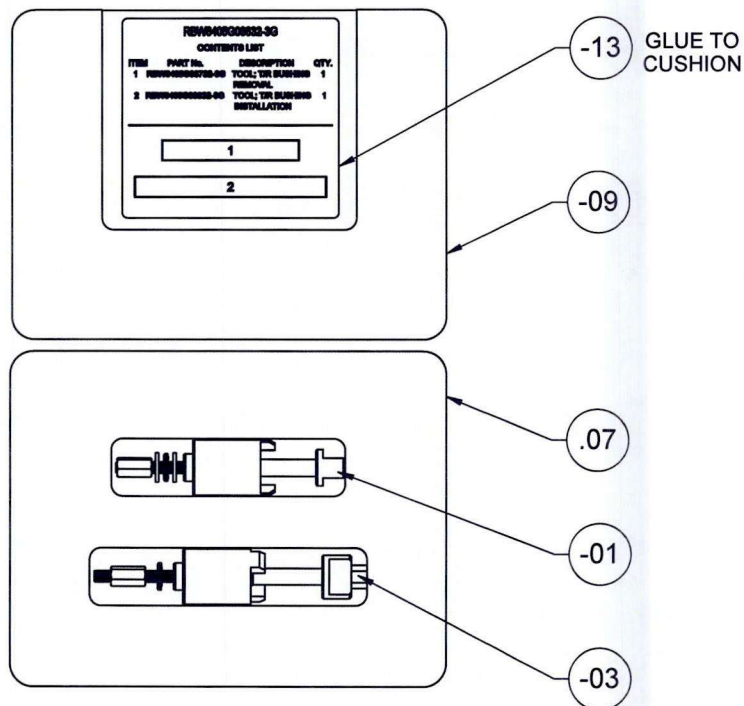
Part Specifications

Specifications could not be found.

Plex 7/9/19 3:40 PM Dart.Sauve.Jean-Francois

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
A	SEPERATED OUT FROM KIT	3/14/11	JAG RW
B	-13 CH'D LETTERING COLOR WAS ALUMINUM IS WHITE. CH'D MATERIAL IN BOM WAS ALUMINUM IS PLASTIC. -9 CH'D MATERIAL WAS EPDM IS Y-20, BLACK.	3/12/13	BIM RJC



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194338 MLC
19-04-30

B/O	PART #	QTY	DESCRIPTION	MATERIAL	B/O INFORMATION	Pg
	-01	1	T/R BUSHING REMOVAL TOOL		T/N RBW6405G08732-3G	1
	-03	1	T/R BUSHING INSTALL TOOL		T/N RBW6405G08832-3G	1
B/O	-05	1	HARD CASE	PLASTIC	PELICAN #20P-1200-E	N/S
B/O	-07	1	BOTTOM TOOL PROTECTOR	Y-20; BLACK	3 x 7-1/4 x 9-1/2 I.R. SPECIALTIES	2
B/O	-09	1	TOP TOOL PROTECTOR	Y-20, BLACK	1-3/16 x 7-1/4 x 9-1/2 I.R. SPECIALTIES	3
B/O	-11	1	RB PLACARD, (on case top)	ALUMINUM	RB41009	N/S
B/O	-13	1	INSIDE PLACARD, (lasered)	PLASTIC	1/32 x 4-5/16 x 4-11/16	4

RED BARN MACHINE	
TITLE	
TAIL ROTOR BUSHING KIT	
DWG NO.	REV
RBW6405G08632-3G	B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY: PERRITT
DECIMALS .XXX ± .005	APPROVED
XX ± .01	HEAT TREAT
X ± .1	FINISH SPEC
METRIC .X ± .1mm	
FRACTIONS ± 1/32	
ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 8-24-10
SHEET 1 of 4	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					